

Date: Monday, 09/02/2009 4:31:25 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE POSITIONER
Job Number :	45653		
Estimate Number :	13530		
P.O. Number :		Part Number :	PB674300127
This Issue :	09/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.4
First Issue :	/ /	Project Number :	N/A
Previous Run :	45652	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	29/04/2009
Written By :		Qty:	2
Checked & Approved By :	<u>MW 09-03-05</u>	Um:	Each
Comment :	Est Rev:A 08-07-29 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300135	PB67-43001-35 Lower Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-35 Lower Pad Assembly

batch: B45030

CPL 09.04.22

2.0	PB674300131	PB67-43001-31 Upper Restraint Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-31 Upper Restraint Weldment

batch: B45031

CPL 09.04.22

3.0	PB674300129	PB67-43001-29 Blade Positioner Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-29 Blade Positioner Weldment

batch: B47050 B45032

CPL 09.04.22

4.0	PB6743001285	PB67-43001-285 Upper Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-285 Upper Tube

batch: B44974

CPL 09.04.22

5.0	PB674300119	PB67-43001-19 Inner Tube and Retainer Bu
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-19 Inner Tube and Retainer Bu

batch: B45039

CPL 09.04.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:31:25 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45653

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001293

Extension Tube Adjustmnt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Extension Tube Adjustmnt

batch:

41882 x1, 40001 x1

SS 09/04/22 (X2)

7.0

PB6743001289

Handle Adjustmnt Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Adjustmnt Fitting

batch:

40246

SS 09/04/22 (X2)

8.0

PB6743001291

Clamp Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp Bushing

batch:

44972

SS 09/04/22 (X2)

9.0

AN622A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch:

M110155

SS 09/04/22 (X2)

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch:

M110985

SS 09/04/22 (X2)

11.0

NAS1149F0632P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch:

M18057

SS 09/04/22 (X2)

12.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch:

M108982

SS 09/04/22 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:31:25 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45653

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L6

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

batch:

M110002

SS 09/04/22 (x2)

14.0

MS27039109

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s)

Screw

batch:

M107378

SS 09/04/22 (x2)

15.0

NAS1149F0316P

WASHER



Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s)

WASHER

batch:

M111124 x13 M111117 x1

SS 09/04/22 (x2)

16.0

MS27039104

Inventory



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Inventory

batch:

M18431

SS 09/04/22 (x2)

17.0

MS24694S102

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch:

M14604

N/A

SS 09/04/22 (x2)

18.0

AN526A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

BOLT

batch:

M18057 x1 M111424 x1

N/A

SS 09/04/22 (x2)

19.0

NAS1149F0532P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

M18057

N/A

SS 09/04/22 (x2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:31:26 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45653

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

batch: M109846

N/A

h

SS 09/04/22 (x2)

21.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

batch: M108967

N/A

h

SS 09/04/22 (x2)

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- slide -289, -291 and -293 on -19 tube then slide it in -285 tube
2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg
3- assemble all parts as per dwg PB67-43001

09.04.23
09.04.22

2

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/23 (x2)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 45648

09/4/23 (2)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

Job Completion



MF 09-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

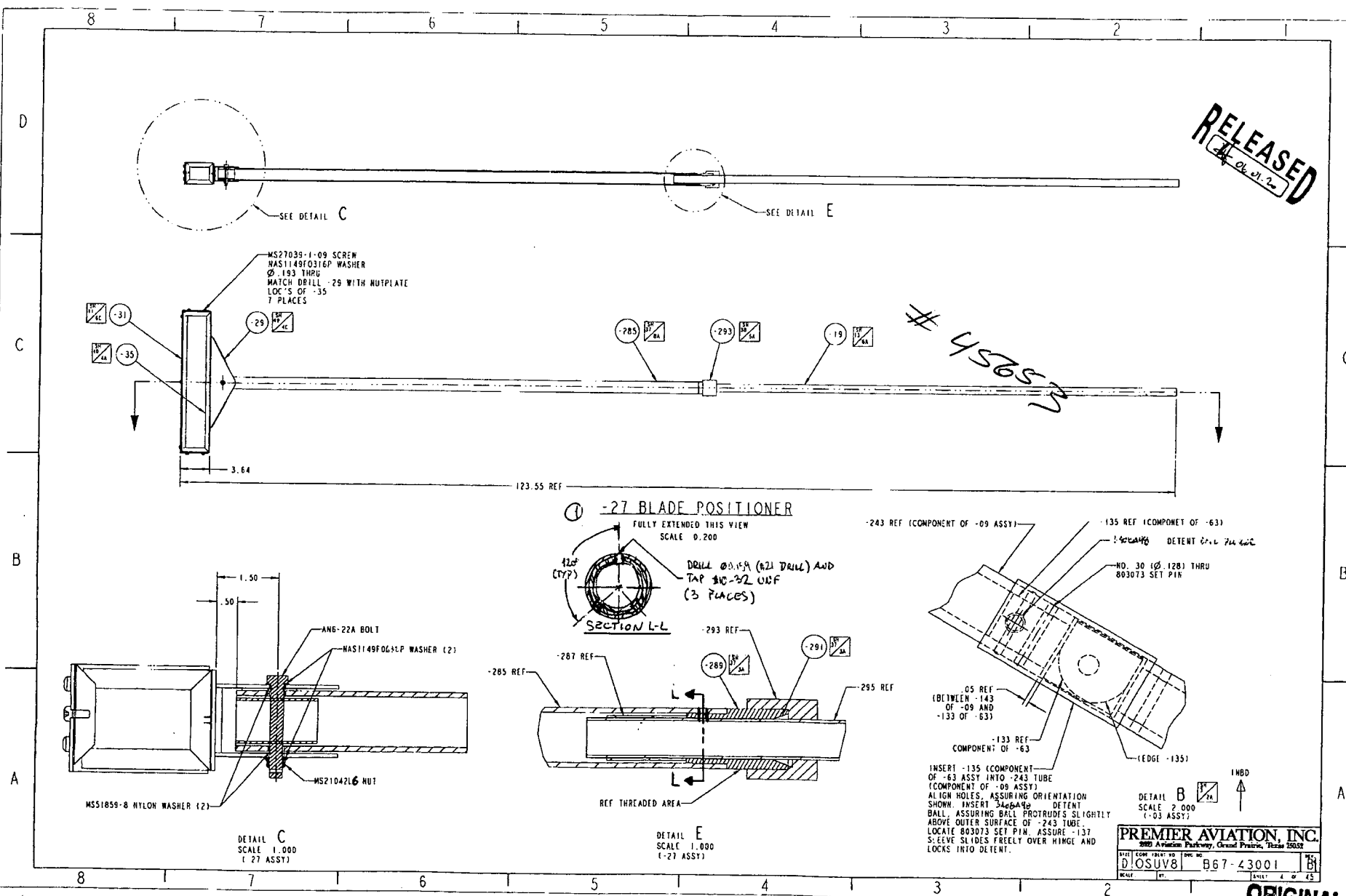
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
45653



PREMIER AVIATION, INC.
2880 Aviation Parkway, Grand Prairie, Texas 75052
DETAIL B SCALE 2.000 (-03 ASSY)
D10SUV8 B67-43001
SHEET 4 OF 43

ORIGINAL